

Work Order ID 67998

Tuesday, April 05, 2011 10:47:32 AM



Page 1

Item ID: D4380-23

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cover, Large Hoist Control Panel

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Run Start



Approvals: Process Plan: MF

Date: 11-04-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4380

RA6, PAZ OK 11/04/05 ADD

100



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB
11/04/05

105



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: 150°F

Time IN: 6:00 pm

11/04/05

Time OUT: 7:00 am

11/04/05

BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Thermoform	0.00				1			BB 11/04/05
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA121 using tool DT9746 Dwg Rev: PA 7 Folio Rev: A								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00				1			BB 11/04/05
Quality Control	Memo Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
	QC	0.00				1			DE 11/04/05
Quality Control	Memo								

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Page 3

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Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

Dh.
11/04/05

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

Dh.
11/04/05

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

- Inspectors to Part
Day only
Subokas *FE*

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Page 4

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Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *RECALL*

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE *11/05/13*AUTH *mf*RELEASED *mf*DATE *11/05/13**11-04-06**R02370*

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:47:30 AM

Page 1

Work Order ID: 67998

Parent Item: D4380-23

Parent Item Name: Cover, Large Hoist Control Panel

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue. 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

116576

Loc Qty

787.2912

787.2912

Loc Code

3.46875 sg OK.

DL
11/04/04

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 67998
Description: Large West Catal Panel cover	Part Number: D4380-23
Inspection Dwg: D4380 Rev: PA 7	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: <u>11/04/05</u>
-------------------------------	------------------------------

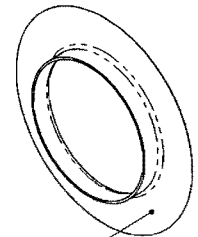
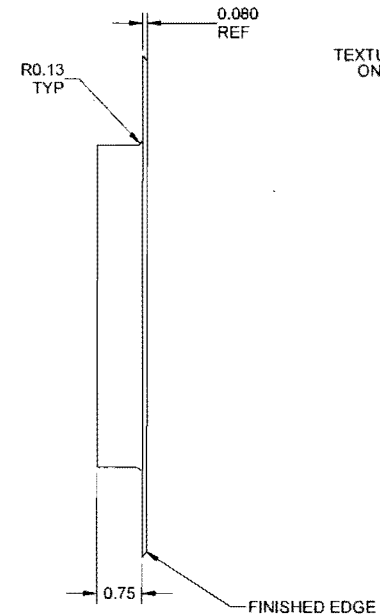
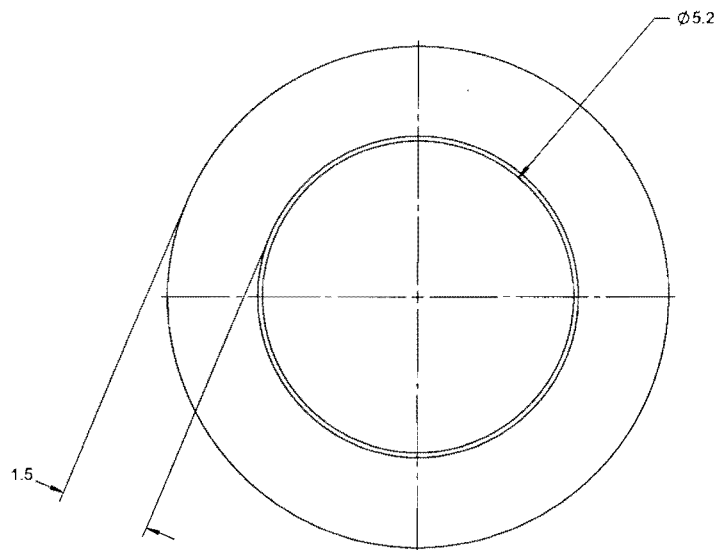
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>5.2</u> "		<u>5.187</u> "	✓		<u>Check DL-07</u>	
<u>1.5</u> "		<u>1.5</u> "	✓		<u>Tape DL-01</u>	
<u>.75</u> "		<u>.742</u> "			<u>Visual DL-03</u>	

Measured by: <u>DL</u>	Date: <u>11/04/05</u>
Audited by: <u>S</u> <u>inspected to part drawing</u>	Date: <u>11/04/06</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-23 COVER, LARGE HOIST CONTROL PANEL

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -23 PART PER MOULD DT9746.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

DL 11.04.05

DESIGN	<i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DL</i>		
CHECKED		DRAWING NO. D4380	REV. PA7 SHEET 12 OF 19
MFG. APPR.		TITLE CEILING POCKETS	SCALE NTS
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DE APPR.			
DATE	11.04.05		

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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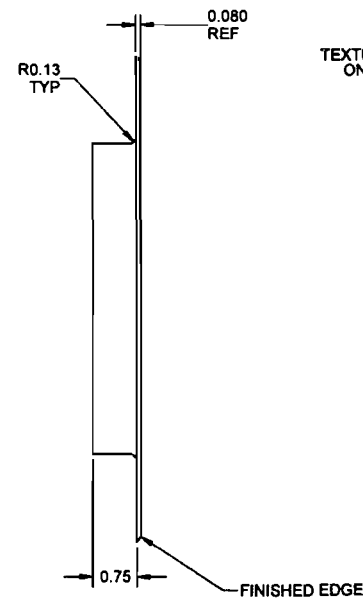
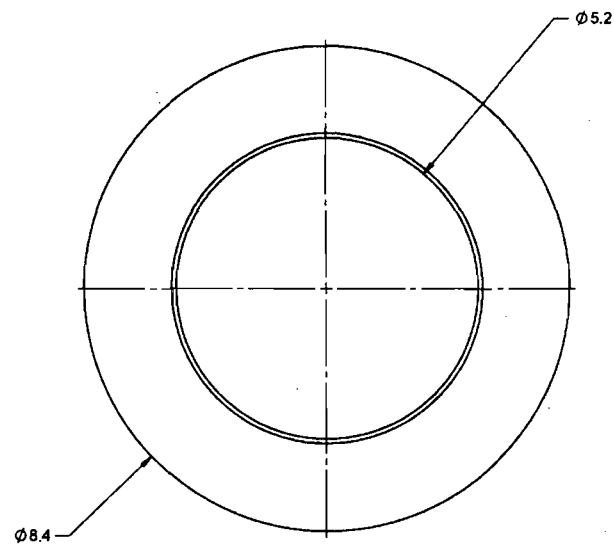
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D4380-23 COVER, LARGE HOIST CONTROL PANEL

67998

RELEASED
2011-05-10

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.17 lbs
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- 9) TOOLING: THERMOFORM PER MOULD DT9746 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	D4380	SHEET 12 OF 19
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CEILING POCKETS	NTS
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